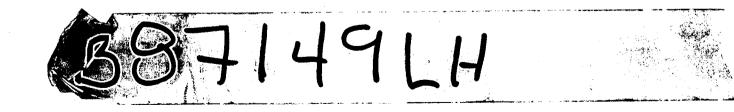
Work Orde July-11-12 8:58		7149		*87	149*							Page 1
Item ID: Revision ID:	D350-636-0	017		Accept	*N900	040	100)*	Setup		*N:	S1*
Item Name:	Skidtube w/ 7	Training Wearplates, LI	1							Stop	*N:	S2*
Start Date: Required Date:	7/05/12 8/24/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item : Customer:							
Reference:		·.	'									
Approvals:	Process Pl	an:	Date/207-1	Tooling:	D	ate:			Run	Start Stop	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				ыор	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
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D4168	A											
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DC		Memo		0.00	. 44		- , <	7	<u></u>			7 . Annual 2011 - Samuel Cont. (10)
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W/O:	•		\\/	ORK ORDER CHANG	EG					
DATE	STEP	PR	OCEDURE CHA			Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR:	Yes	No DQ	A:	Date:	
	Resolution:		Disposition	on: <u>`</u>	QA: N	VC CIC	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)			
		Description of NC	Description of NC Corrective Actio				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

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W/O:			W	ORK ORDER CHAN	GES			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Re	solution:	Dispositio	n: <u>`</u>	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORM	MANCE (NCF	1)		
DATE	STEP	Description of NC			ection B	Verification	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 87149 *87149* Page 3 July-11-12 8:58:24 AM Item ID: D350-636-017 Accept *N900040100* Setup Start **Revision ID:** Item Name: Skidtube w/ Training Wearplates, LH Start Oty: 1.00 **Start Date:** 7/05/12 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 8/24/12 Customer: Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): QC: Date: Set Up/ Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ Operation Accept **Work Center ID** Qty Number Stamp Code Qty **Description Run Hours** 11-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 12-Grind welds flush as per Dwg D4168 120 QC10- Inspect visual per QSI004- ground welds *120* QC Memo Quality Control 130 QC5- Inspect part completeness to step on W/O

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Quality Control

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W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CH	IANGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	s No De	QA:	Date: _			
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NCR:			WORK OR	DER NON-CONFORI	MANCE (N	CR)					
DATE	STEP	Description of NC	Corrective Action		ection B		fication		Approval		
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	Work Order ID 87149 uly-11-12 8:58:24 AM		*87149*								Page 4
Item ID: Revision ID:	D350-636-0	17		Accept	*N900	040	100)* s	Setup Sta	I V	S1*
Item Name:	Skidtube w/ T	raining Wearplates, LH							Sto	^p *N	S2*
Start Date: Required Date: Reference:	7/05/12 8/24/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Pla	nn:	Date:	Tooling:	Di	ate:		F	Run Sta	!/	R1*
1 Approvision			Date:	SPC (Y/N):		ate:			Sto	^p *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		Chemical Conversion Coa	t per QSI005 4.1	0.00						a	
140 HandFinish Hand Finishing		Memo		0.00						6_/	2.8.2
150		QC7-Inspect Chemical Co	onversion Coat	0.00						,	ı
150		Mama		0.00					B	12/0	28/02

0.00

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Resolution:			Disposition	QA: N/C Clo	sed:		Date: _		
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DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approvai	Approval
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Work Orde July-11-12 8:58				*871	49*					.:		Page	5
Item ID: Revision ID:	D350-636			Accept	*N90	NN4 N	100)* 5	Setup		*N:	S1*	
Item Name:	Skidtube w	// Training Wearplates, LH								Stop	*N:	S2*	
Start Date: Required Date: Reference:	7/05/12 8/24/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Iten Custome								
Approvals:	Process	Plan:	Date:	Tooling:		Date:	_	I	kun	Start	*N	R1*	
						Date:				Stop	*N	R2*	
Sequence ID/ Work Center II 160)	Operation Description Skidtubes		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	· · · · · · · · · · · · · · · · · · ·
160 Skidtubes		Memo		0.00									-
Skidtubes		I-Open up ho side) as per dwg D 2-Open up ho as per dwg D 3- Open float 4-Chamfer ho (welding inst	oles of Detail B to 0.750 4168. t hole to 0.500" (4 per s	und handling and float hole				\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	B	12/08/	lor	•	
		7-Bond web A/R Sikat 8- Weld spac	D2739 in place as per (flex-291 batch:_ex	$\frac{251015}{122130}$ p. date: $\frac{13}{9}$ and D2743 as per dwg D41		12/20/	/						

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

W/O:		WORK ORDER CHANGES													
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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		PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	4 :	_ Date: _						
		esolution:													
NCR:			WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section	n B		Verific	ation	Approval	Approval					
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Work Ord <i>July-11-12 8:58</i>		7149		*87149*								Page 6
Item ID: Revision ID: Item Name:	D350-636-(017 Training Wearplates, LH		Accept	*N900	040	100)*	Setup S	tart Stop	*N!	S1* S2*
Start Date: Required Date: Reference:	7/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					IVA	. 7/
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:				tart Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II)	dwg D2750 12- C'bore se 13- Deburr ho	ction CJ-CJ	Set Up/ Run Hours ection (total of 4 places pe	9-10	j	Plan Code	Accept Qty	Rejec Qty		leject lumber	Insp. Stamp
170 *170* QC Quality Control		QC10- Inspect visual per (QSI004- ground welds	0.00 (PAS)	volvelo					 - 		

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QC5- Inspect part completeness to step on W/O

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W/O:			WC	RK ORDER CHANG	iES .			,
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		<u>.</u>	tion B	Verification	Approval	Approval
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Work Order ID 87149 <i>July-11-12 8:58:24 AM</i>				*871	49*					Page 7
Item ID: Revision ID: Item Name:	D350-636-017	7 aining Wearplates, LH		Accept	*N900	04010	n *	Setup Start	147	11* 22*
	7/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				
Approvals:	Process Plan	:	Date:	Tooling:	D	ate:	1	Run Star	' *NR	21*
F F						ate:	-	Stop	*NF	22*
Sequence ID/ Work Center II 190 *100* HandFinish	D	Operation Description Pressure Wash per QSI005	5 4.3	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	e Qty	Qty		nsp. Stamp
200 *200* Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) p	per QSI005 4.3-Alum 7 - 45 E:	0.00 0.00 0.00			-/χ	- Y		M/ 12/09/11
210 *210* QC Quality Control	L1841	QC3- Inspect Part Finish Memo	reign object per QSI 024	0.00			<u> </u> W(ıd	H	nloal

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W/O:			WORK ORDER CHANGES											
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Part No	•	PAR #:	Fault Ca	ategory:	NCR	: Yes N	lo DQ	\: <u> </u>	_ Date: _					
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SIKA FLEX 241 BATCH: /// 172443

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

5-Coat all exposed fasteners with "LPS Procyon" batch: 111594

A/R 55-o'ring lube batch: M\\2\65

EXP DATE:

Insp.

Stamp

Page 8

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1	N/O: 81	7149	WORK ORDER CHANGES					
	DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
) (9-13	JH)	Premare D4154-041 x 1 B 85812 and surap per ean. 12-650- - Replace with new D4154-041 x 1 B 90298					,
			at rev. E.					

Part No: 0350-636-017 PAR #:_	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition: `	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B	Verification	Approval	Approval						
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Work Ord		87149		*871	149*						Page 9
Item ID: Revision ID: Item Name:	D350-63	86-017 w/ Training Wearplates, LH		Accept	*N900	040	100	ገ* ፡	Setup St		NS1* NS2*
Start Date: Required Date: Reference:	7/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:					14.57
Approvals:		s Plan:	Date:	Tooling: SPC (Y/N):		ate:		I		art *	NR1* NR2*
Sequence ID/ Work Center II 240 *240* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours 0.00 Sm s 0.00 /J-Q-)	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Rejec Numl	
250 *250* Packaging Packaging		Pick Kit Memo		0.00				1×			D-10
260 *260* QC Quality Control		QC4- 100% Inspect kits Memo ******ensu	for completeness re antiseize is on AN8C2	0.00 0.00 1A bolts******	sirlioly					·	

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DATE	OTED	Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
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·Work Order ID 87149 *87149* Page 10 July-11-12 8:58:24 AM Item ID: D350-636-017 Accept *N900040100* Setup Start **Revision ID:** Stop Skidtube w/ Training Wearplates, LH Item Name: 7/05/12 Start Oty: 1.00 **Start Date: Cust Item ID:** Required Date: 8/24/12 Req'd Qty: 1.00 **Customer:** Reference: Start Run Process Plan: Date:_____ **Tooling:** Date: Approvals: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Reject Reject Operation Set Up/ Tool ID Tool # Plan Accept Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp 0.00 270 Packaging *270* 0.00 Packaging Memo Packaging Identify and pack for shipping as per PPPD350-636-017 Location: PPP rev: 280 QC21- Final Inspection - Work Order Release 0.00 *280* 0.00 Memo

Quality Control

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Picklist Print

July-11-12 8:58:22 AM

Work Order ID:

87149

Parent Item:

D350-636-017

DD verf:EC

Parent Item Name:

Skidtube w/ Training Wearplates, LH

Start Date: 7/05/12

Required Date: 8/24/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP rev:A 10.09.28 new issue DD verf:EC

IPP Rev:B 11.04.14 ecn11-553 IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC

IPP

AN3C34A BOLT	 Purchased	No			Seq ID		Hand		Qty	Issued	Issued	
BOLI					230	Each	31.0000	1	1	ıılo	9/11	
			Location		Loc Qty	Lo	oc Code					
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AN3C36A	Purchased	No			230	Each	195.0000	4	101 4			. /
BOLT								 	_Λ(0 7 1	
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AN3C37A BOLT	Purchased	No			230	Each	152.0000	1	M_1	99E	438	SP_
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Work Order ID:	87149				~			
Parent Item:	D350-636-017					Start I	Pate: 7/05/12	Required Date: 8/24/12
Parent Item Name:	Skidtube w/ Training Wearplates, LH					Start	Qty: 1.00	Required Qty: 1.00
/ AN3C42A BOLT	Purchased	No		230	Each	67.0000	1	D. 12-10-10
>			Location	Loc Qty		Loc Code	_	
			ST354	67			-	_
			106176	1				_
			120464	1				_
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			122241	50			-/X	_
D3490-1	Manufactured	No		160	Each	79.0000	14	4 BE12/08/39
Cross Bolt Spacer						. /	//	06/2/08/30
			Location	Loc Oty		Loc Code	/-	B 88617' 23
			LG	68				
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D3490-5	Manufactured	No		230	Each	31.0000	4	4 00 /0/
Cross Bolt Spacer	Managara							* BF 12/08/30
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D3492-1	Manufactured	No		230	Each	157.0000	8 4.1	8
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No	DQA	•	Date:	<u> </u>
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)				
		Description of NC		Corrective Action Sect	ion B		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da		Sectio		Chief Eng	QC Inspector
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Work Order ID:	87149								
Parent Item:	D350-636-017						Start	Date: 7/05/12	Required Date: 8/24/12
Parent Item Name:	Skidtube w/ Training	Wearplates, LH					Start	Qty: 1.00	Required Qty: 1.00
D3492-5 Plug		Manufactured	No		230	Each	127.0000	8 11 8	12/09/11
				Location	Loc Oty		Loc Code		
				fpa	127				
				83100	26				
				83530	101			$ ^{\lambda}_{\mathcal{S}}$	
D3873-1 Bushing		Manufactured	No		230	Each	332.0000	7 YL 7	12/09/14
				Location	Loc Oty		Loc Code		
				ST057	6				
				79561	6				
				ST067	326				
				64760	1				
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				73829	19				
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				<u>76791</u>	280			_X- 1	
				79560	20				
D4154-041 Wearplate Assembly		Manufactured	No		230	Each	1.0000	'lk'	12/08/4
				Location	Loc Qty		Loc Code	139029	8 KI)
				FP001	1		000013		
				83219	1		-B85818		
D4170-1 Bushing		Manufactured	No		230	Each	63.0000	4	BE 12/08/30
•				Location	Loc Oty	•	Loc Code		
				LG	50			,	
				82222	50			4	
				LG001	13				
				71844	5				
				82043	8				

										•				
W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
										,				
				,										
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes N	lo DQ /	A:	Date:					
	R	esolution:	Dispositio	n: <u>`</u>	_ QA: f	VC Clo	sed:		Date:					
NCR:		\	WORK ORD	ER NON-CONFORMA	ANCE	(NCR)								
DATE	STEP	Description of NC			ion B	C: 0	Verific		Approval	Approval				
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector				
		·						:						
	† · · · · · · · · · · · · · · · · · · ·	-			<u></u>		<u> </u>							
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" July-11-12 8:58:22 AM

Work Order ID:	87149								
Parent Item:	D350-636-017						Start D	ate: 7/05/12	Required Date: 8/24/12
Parent Item Name:	Skidtube w/ Training	Wearplates, LH					Start (Qty: 1.00	Required Qty: 1.00
D4171-1 Bushing		Manufactured	No		230	Each	12.0000	1 14	1 Nogli
				Location	<u>Loc Oty</u>		Loc Code		
				ST104	12				
				82385	12			<u></u>	
MS21043-3 Nut		Purchased	No		230	Each	1,060.0000	⁵ M	5 noglu
				Location	Loc Qty		Loc Code		
				FG	72				
				103691	72				
				ST301	988				
				118077	2				
				118614	12				
				118686	30				
				119758	20				
				121255	67			-15	
V + C44 +0 C02 (2D				121708	857	Б.	2 005 0000		
NAS1149C0363R Washer		Purchased	No		230	Each	3,005.0000	<u>")) </u>	94/09/11
				Location	Loc Qty		Loc Code		
				ST297	3005				
				114742	2805				
				122063	200			X	
NAS1149D0863J WASHER		Purchased	No		250	Each	221.0000	2	6-10-10
				Location	Loc Qty		Loc Code		
				ST298	221				
				118078	34				
				119307	1				
				120308	86			\rightarrow X	
				121556	100				

Dart Ae	rospace	e Ltd								, 1
W/O:			W	ORK ORDER CHAN	IGES					· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	egory:	NCF	R: Yes N	lo DQ	A:	Date: _	
	R	esolution:	Dispositio	on: `	QA:	N/C Clo	sed:	· · ·	Date: _	
NCR:		V	VORK ORD	ER NON-CONFOR	MANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial	Action Description	ection B	Sign &	Verific Secti		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date		·	-	

;July-11-12 8:58:23 AM

Work Order ID:	87149						
Parent Item:	D350-636-017					Start I	Date: 7/05/12 Required Date: 8/24/
Parent Item Name:	Skidtube w/ Training Wearplates, LH					Start	Qty: 1.00 Required Qty: 1.00
NAS1515H3L WASHER	Purchased	No		230	Each	307.0000	4 HL 4 Wogli
			Location	Loc Oty		Loc Code	
			FG	40			
			102472	40			
			ST277	267			
			118686	3			
			120360	11			
			121556	53			
			122151	200			<u> </u>
AS1611-005 0-RING	Purchased	No		230	Each	132.0000	8 M8 Wogly
			Location	Loc Qty		Loc Code	
			FP001	132			
			106099	18			
			114220	38			
			119438	36			<u> </u>
			121415	40			X
AS1611-010 -RING	Purchased	No	•	230	Each	368.0000	8 H8 4 09 1
			Location	Loc Qty		Loc Code	
			FP001	368			
			110915	14			
			117460	8			
			118077	1			
			118612	3			
			119438	47			
			121259	2			AND ADDRESS OF THE PARTY OF THE
			121584	.2			
			121723	15			
			122151	276			<u> </u>

W/O:			W	ES			·	
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1100 1119	
		,						
	·							:
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes 1	No DQA:	Date: _	
•	R	esolution:	Disposition	on: <u>'</u>	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			-
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								,

,July-11-12 8:58:23 AM

Work Order ID:	87149								
Parent Item:	D350-636-017					Start l	Date: 7/05/12		Required Date: 8/24/12
Parent Item Name:	Skidtube w/ Training Wearplates, LH					Start	Qty: 1.00		Required Qty: 1.00
D2744 Cap	Manufactured	No		110	Each	60.0000	1	1	BE 12/07/26
			Location	Loc Oty		Loc Code			/ /
			LG002	60					
			62715	1					
			83412	21				-	
			85506	38			-		
D2600-3-BENT Extrusion Bent	Manufactured	No		110	Each	33.0000	1	1	OF 12.7.26
			Location	Loc Oty		Loc Code			
			LG	33					
			66875	7					
			73253	1					
			75021	1					·
			75022	1					
			75023	I					
			81330	4				—	
			83305	1					
			(86330)	17					
D2743 Crossbolt Spacer	Manufactured	No		160	Each	152.0000	8	8	BE12/08/3
Crossoon spacer			Location	Loc Qty		Loc Code			B 86896 ×£
						<u>Doc Code</u>			00010 ~0
			LG	78					
			81965 83262	23 55					
									
			LG001	74					
			67766	4				—	
			68251	3					
			73403 74445	. 64					
			74445 79517	\1 2					
			19311	2					

	•								
W/O:			W	ORK ORDER CHANG	ES			·	
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
		solution:							
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
									:
									:

. July-11-12 8:58:23 AM

Work Order ID:	87149								
Parent Item:	D350-636-017						Start D	Date: 7/05/12	Required Date: 8/24/12
Parent Item Name:	Skidtube w/ Training Wearplates, LH						Start	Qty: 1.00	Required Qty: 1.00
D2739 350 I Beam	Manufactured	No			160	Each	14.0000	1 1	12/08/02
			Location	1	Loc Oty		Loc Code		· · · · · ·
			LG		14				
				72155	1				
				81508	1				
				83448	2				
				83548	1				
				85486	5				
				86615	4				
ALS4-1932-225 Insert	Purchased	No		87734	230	Each	2,664.0000	4) 4	11/09/11
			Location	<u>1</u>	Loc Qty		Loc Code		
			FP-B		2221				
				122290	2221			VJ	
			ST281	-	420				
				108696	146				
				110768	62				
				118386	55				
				118966	68				
				121269	89			-	
			ST282		23				
				120410	10				
				120451	13				
AN8C35A BOLT	Purchased	No			230	Each	55.0000	1 11 1	uloglu
			Location	<u>1</u>	Loc Qty		Loc Code		
			FP002		54				
				115960	1				
				118286	3				
				121275	50			X)	
			ST346	`	1			, , , , , , , , , , , , , , , , , , , ,	
				114442	0				
				115188	0				
				115960	1				
L.L. 11 12 0.50.2	2 414				alsat Drint				Daga

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			3						
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	n: <u>`</u>	_ QA: N/C CI	osed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Work Order ID:	87149							
Parent Item:	D350-636-017					Start Da	ate: 7/05/12	Required Date: 8/24/12
Parent Item Name:	Skidtube w/ Training Wearplates, LH					Start Q	Qty: 1.00	Required Qty: 1.00
D3488-041 Blade Fitting Assembly,	Manufactured	No		230	Each	25.0000	1)	1 12/08/4
		Lo	ocation	Loc Oty		Loc Code		
		FF	2001	8				
			85807	8				
		FF	2002	17				
		• •	83407	10			- V (
			85733	7				
AN6C44A BOLT	Purchased	No		230	Each	84.0000	4 14	1 1109/11
		Lo	ocation	Loc Oty		Loc Code		
		FC	Ĵ	2				
			103964	2				
	•	S7	Г343	82				
			121013	11				
			121440	21	11	122491	V U	
			122204	50	, ,			
MS21083C8	Purchased	No		230	Each	88.0000	1 H	1
NUT								110914
	of de	Lo	ocation	Loc Qty		Loc Code		
		30)4	33				
			121185	16				
			121349	17		•		
		FF	2002	1				
			115884	1			-	
		ST	Г303	4				
			115884	0				
			118077	1				
			119309	2				
			119638	1				
		ST	Γ321	50				
			122141	50			αι	

		, 								
W/O:			WO	RK ORDER CHANG	BES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:				•	
		,								
Part No	:	PAR #:	Fault Categ	NCR: Yes No DQA: Date				_ Date: _		
	Re	esolution:	Disposition): <u>`</u>	QA: N/C Closed:			Date:		
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Initial Action Descrip		tion B	on B Sign &		Verification		Approval
		Section A	Chief Eng	Chief Eng		Date	Sectio	n C	Chief Eng	QC Inspector
				······································		· · · · · · · · · · · · · · · · · · ·				
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Work Order ID:	87149										
Parent Item:	D350-636-017					Start Date: 7/05/12 Required Date					
Parent Item Name:	Skidtube w/ Training	g Wearplates, LH					Start	Qty: 1.00		Required Qty: 1.00	
D3631-1 Washer		Manufactured	No		230	Each	235.0000	8 JU	8	11/09/11	
				Location	Loc Qt	<u>Y</u>	Loc Code				
				FG	22	20					
				81874	1	2					
				83588	2	8		Ϋ́			
				ST072		15		-			
				68062		2					
				75548		13		-			
AN960C10L washer	NAS1149C0332R	Purchased	No		230	Fach	21.0000	11120	63	(va) ll moder	
				Location	Loc Ot	<u>Y</u>	Loc Code				
				ST		21					
				10753	34	21		<u> </u>			
D2745 Bushing		Manufactured	No		230	Each	210.0000	* Jy	8	1108/111	
				Location	Loc Qt	<u>Y</u>	Loc Code				
				FP	19	98					
				79518		6					
				85416	5 19	92		X 8			
				FP001		12					
				69529		1					
				76142		1					
71 - C44 40 C0044P				83260		10	244.0000				
NAS1149C0832R WASHER		Purchased	No		230	Each	244.0000	<u>') </u>	1	11/09/10	
				Location	Loc Ot	Y.	Loc Code				
				ST297	24	14		-			
				11491	15 24	14		VI			
					-						

Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PR(OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· .				٠			
									-	
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes 1	No DQ	A:	Date: _	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)				
0.475		Description of NC		Corrective Action Sec	tion B		Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	;	Section C		Chief Eng	QC Inspector	
				-			ļ			
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NOTE: Date & initial all entries

D3493-1 250 97.0000 Manufactured Each No Washer Location Loc Qty Loc Code ST050 97 77573 82023 2 83097 94

Dart Aerospace Ltd

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W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
									<u>ئ</u>				
Part No	•	PAR #:	Fault Cate	jory:	_ NCR: Ye	•							
	R	esolution:	Disposition); <u>`</u>	QA: N/C	Closed:		Date:					
NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval				
DAIL	0.1.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	Sect	ion C	Chief Eng	QC Inspector				
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NOTE: Date & initial all entries

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Work Order ID:	87149									
Parent Item:	D350-636-017						Date: 7/05/12	Required Date: 8/24/12		
Parent Item Name:	Skidtube w/ Training Wearplates	, LH				Start Qty: 1.00		Required Qty: 1.00		
MS21083C8 NUT	Purchased	No		250	Each	88.0000	2 M	3224525P		
		Loc	cation	Loc Oty		Loc Code		\mathcal{A}		
		304		33						
			121185	16				_		
			121349	17			M - 181 - 181 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187 - 187	_		
		FP0	002	1				_		
			115884	1				····		
		ST3	303	4				_		
			115884	0			MAL - MITTHEW TO THE	_		
			118077	1				_		
			119309	2		•		·-		
			119638	1				_		
		ST3	321	50						
			122141	50						
N8C21A	Purchased	No		250	Each	77.0000	2	(2)		
OLT	, aremasec	•						111122204.8		
		Loc	cation	Loc Qty		Loc Code				
		ST3	343	77				_		
			118758	3				_		
			121275	24			-	-		
			· 122204	50				_		
02741 Blade, 350 Skidtube	Manufact	ured ^{No}		250	Each	32.0000	1 B	75480 SP 5		
		Loc	cation	Loc Qty		Loc Code	1	-10-10		
•		ST	 .	-10			10	, , , , , .		
		ST4	166	42			4.15-1	_		
		514	71856	1				-		
			83135	31				-		

Dart Aerospace Ltd

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W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector						
*														
Part No	:	PAR #:	Fault Cated	jory:	NCR: Yes	s No DO	A:	Date: _						
	R	esolution:	Disposition	n: <u>`</u>	_ QA: N/C	Closed:		Date: _						
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)		•						
DATE	CTED	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector					
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NOTE: Date & initial all entries

		8		/	
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
Х				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			Х	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4.	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	- 8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
•		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
.4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1		AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5		MS21043-3	NUT
4	4	4		MS21043-6	NUT
1	1	1		MS21083C8	NUT
4	4	4		NAS1515H3L	WASHER

GENERAL NOTES:

MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0). FINISH:

MATERIAL: MIRAE D4186-11-27-9-4 FROM D2800-3 EXTROSION (INITIAL LENGTH = 120.0).

FINISH:

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.35.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A
IDENTIFICATION: N/A

WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS

WELD PER DART QSI 004

FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 35 KSI

MINIMUM YIELD TENSILE STRENGTH = 36 KSI

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

81149 R120212

			•										
Α	NEW IS	SUE		10.08.09									
REV.			DESCRIPTION	BY	DATE								
DESIGN	1	sc	DART AEROSPA	DART AEROSPACE USA, INC.									
DRAWN	V /	SC	PORT HADLOCK, WA										
CHECK	CHECKED (1)		DRAWING NO.	REV. A									
MFG. A	PPR.	1	D4168		SHEET 1 OF 11								
APPRO	VED	WP	TITLE		SCALE								
DE APP	PR.	4-] 350 SKIDTUBE AS	SSEMBL	Y NTS								
DATE	10.0	8.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT OF SHINNIN MICH DEPOSED FOR A SUPPLIED ON THE EXPRESS CONSTRONT WAY! IT IS NOT TO BE USED FOR ANY PLAYODES OR COMMENDATION TO ANY OTHER PERSON WITHOUT										

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NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
								·		QA Closed:	Date:	•
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
Part No					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Date	Date Step Qty or Non-conformance			Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material	_											
Setup												
Other	_											
Process	_											
Supplier						1				<u> </u>		
Training	_					ł						·
Unapproved			<u> </u>				TCATE	CORY		<u> </u>		
Landir	ng Gear				General	AUL	T CATE	GURY				
Landir	Bending				Bend		Grain			Ovalized	[Pressure/Forced
}			ntric to (\s\ \-	BOM/Route		Hardwa	ro	}	Over/Under	tolerance	Temperature/Cure
ł	Centre Not Concentric to O/S			" 	Broken/Damaged	Н	ł	on Incomplete		Part Incorre	 	Weld
ŀ	Cracks Crushed/Crimped.			-	Burrs		•	ions Incomplete/U	Inclear	Part Lost/M		Wrong Stock Pulled
ľ	Cuffs Crushed/Crimped			-	Contamination	\vdash	Mainte	•	-	Part Moved] 8
İ	Heat Tre	at			Countersink	-	Mislabe			Positioned V	Vrong	
ŀ	 1	on Strip in	Tube	.	Cut Too Short	-	Misread		-	Power Loss/		Other
ł	Ripples				Drill Holes	_	Offset	•			·	
İ	⊣ ∵	Waves in E	xtrusior	, -	Drawing	\vdash	}	Calibration				
	Turning Sequence			}	Finish		Out of Sequence					

Outside Dimensions

Date: ___

DQA:

Wave/Twist in Tube

H:/FORM\$/Quality Assurance\approved QA/NCRWO Rev G

c some services of the service

D4168-041 350 SKIDTUBE ASSEMBLY, LH

D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASE 1 2010 -09- 1.5

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DESIGN	SC	DART AEROSPACE USA.	INC.							
DRAWN	SÇ	PORT HADLOCK, WA								
CHECKED	N	DRAWING NO.	REV. A							
MFG. APPR.	Ma	ີ D4168 s	SHEET 2 OF 11							
APPROVED	WE	TITLE	SCALE							
DE APPR.	-#-	☐ 350 SKIDTUBE ASSEMBLY	. NTS							
DATE 10.0	8.09	COPYRIGHT © 2010 BY DART AEROSPACE US THE DOCUMENT IS PRIVATE AND CONFEDENTIA, AND IS SUPPLED ON THE EXPRESS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO MAY OTHER	SI TI TANT HORTIGHOD							

NCR: `	Yes / No				WORK ORDER NON-C	COI	NFOR	MANCE / UPI	DATE	QA Closed:	Date:	•,
Work Orde	or:		-		DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No. NCR No.					Scrap Machining Sm Use-as-is Thermoforming Fi			Crosstube Small Fab Finishing Composite	Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier			
Root	Root Desc				ption of work order update		Initial	Act	ion	Sign &		
Cause	Date	l l l i			or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material Setup	-	ŀ										
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Process		1										
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Landir	ng Gear				General							_
[Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to C	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped.		<u> </u>	Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs			Contamination		Mainte	nance		Part Moved			
	Heat Trea	at			Countersink		Mislabe			Positioned V		1
].	Inspectio		Tube		Cut Too Short	<u></u>	Misread	j		Power Loss/	Surge	Other
<u> </u>	Ripples in				Drill Holes		Offset				-	
ļ	Torque W			<u> </u>	Drawing		i	Calibration				
	Turning Sequence				Finish	1	Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

D D4168-044 350 SKIDTUBE ASSEMBLY, RH

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RELEASED 2010 -09- 15

		<u> </u>
DESIGN	sc	DART AEROSPACE USA, INC.
DRAWN	sc	PORT HADLOCK, WA
CHECKED	P	DRAWING NO. REV. A
MFG. APPR.		D4168 SHEET 3 OF 11
APPROVED	L W	TITLE SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY NTS
DATE 10.0	08.09	COPYRIGHT 69 2810 BY DART AEROSPACE USA, INC. THIS DOCUMENT BY REWITE AND CONTROTTINE AND B EITH-ED ON THIS DEVELOR OF CREATION THAT IT IS HIGHTO DIE USED FOR ART ALRIYON, OR COPYED DIS COMMINISTRED THAT OT ART OTHER PRISON HITHOUT

NCR:	ICR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
											,	QA Closed:	Da	te:	
Work Ord	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		1
Part No.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	Root Desc					ption of work order update	- 	Initial	nitial Action			Sign &			
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Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											e ⁿ				
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Landi	ng G	ear				General						•			<u> </u>
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat			D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread				Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Inspection Strip in Tube Ripples in Bend					Drill Holes		Offset			L	J	J -		

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

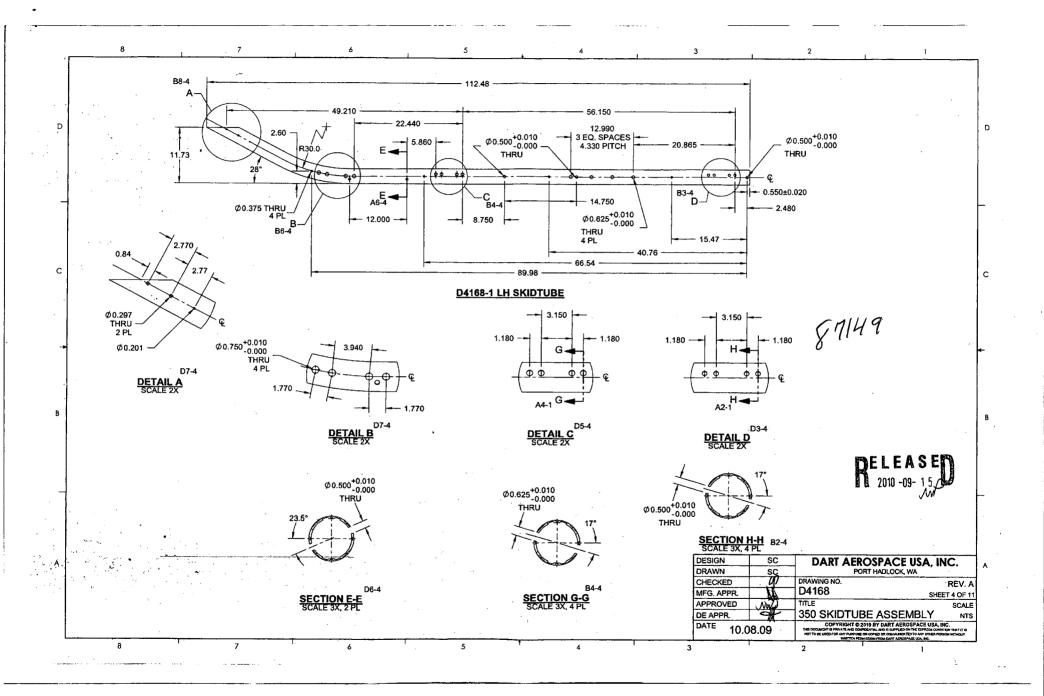
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



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											QA Closed:	Da	te:	
Work Ord	er.					DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS		
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other
Root					Descrip	otion of work order update		Initial	Action		Sign &			
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							AUL	LT CATE	GORY					
Landi		Bending Centre No Cracks		ntric to (D/S	General Bend BOM/Route Broken/Damaged		₹ `	on incomplete		Ovalized Over/Under Part Incorred	ct		Pressure/Forced Temperature/Cure Weld
	Π̈́	Crushed/(Cuffs	·			Burrs Contamination		Mainte			Part Lost/Mi Part Moved	-		Wrong Stock Pulled
		Heat Trea Inspection	strip in	Tube		Countersink Cut Too Short		Mislabe Misread		L	Positioned V Power Loss/			Other
	1	Ripples in	Bend			Drill Holes		Offset	•					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

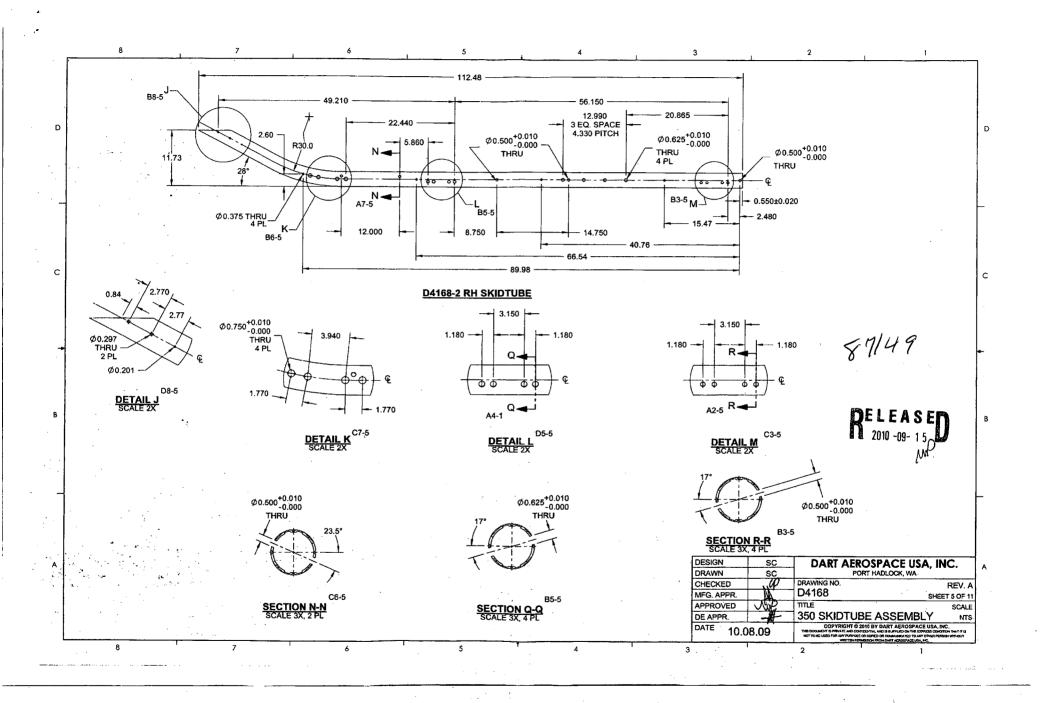
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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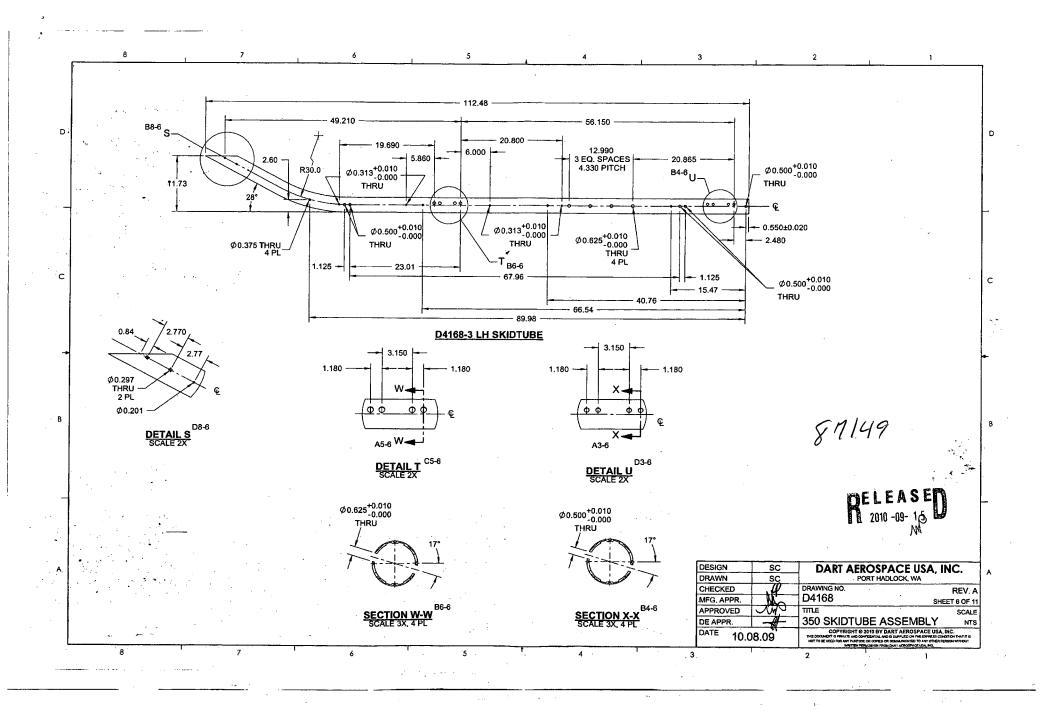


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						DISPOSITION			AGAINST D	EPARTMENT		·
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						Rework			Skid-tube Crosstube		Water Jet	Engineering
Part	No.					Scrap	1	1	Machining Small Fab		d. Eng. Coor.	Quality
						Use-as-is		1	noforming Finishing	Rec/Stor	re/Packaging	Other
NCR	No.					Work Order Update]		Large Fab Composite		Supplier	
Root					Descr	iption of work order update		Initial	Action	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description	Date	Verification	QC Inspector
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Landi						General	_	1	_	٦		1 ₀ /e /
	⊢	Bending				Bend	\vdash	Grain	<u>.</u>	Ovalized		Pressure/Forced
	\vdash	Centre No	t Concer	itric to t	J/3 -	BOM/Route	-	Hardwa	}	Over/Under		Temperature/Cure Weld
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	\vdash	Cuffs Heat Treat			<u> </u>	Contamination Countersink	\vdash	Mislabe		Positioned V		
	\vdash	Inspection		Tubo	<u> </u>	Cut Too Short	\vdash	Misreac	·	Power Loss/		Other
		Ripples in		iube	-	Drill Holes	-	Offset	' <u>L</u>	Trower ross/	Juige	Other
	\vdash	Torque Wa		vtrucion	, H	Drawing		4	Calibration			
		Turning Se		AU 03101	` -	Finish	\vdash	4	Sequence			
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Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



											DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPDATE					;
						· · · · · · · · · · · · · · · · · · ·		,			QA Closed:	Date	.	
Work Ord	er.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		,
Work Ord						Rework	1	ŀ	Skid-tube Crosstube]	Water Jet	٦	Engineering
Part l	No.					Scrap	1		Machining Small Fab		Pro	d. Eng. Coor.	٦	Quality
				,		Use-as-is	1	Thern	noforming Finishing		Rec/Stor	re/Packaging	٦	Other
NCR	No.					Work Order Update]		Large Fab Composite			Supplier		
Root			T	ŀ	Descri	ption of work order update	1	Initial	Action		Sign &		丁	
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng	Description		Date	Verification		QC Inspector
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Equip/Tooling								•						
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Setup							·						-1	
Other													- 1	
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	Н	Centre No	ot Concer	itric to	o/s	BOM/Route	<u></u>	Hardwa)		Over/Under	⊢		Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	<u>_</u>	-	on Incomplete		Part Incorre	<u> </u>		Weld
·		Crushed/0	Crimped.			Burrs	\vdash	4	ions Incomplete/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	<u></u>	Mainte	•		Part Moved			
	Н	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe			Positioned V		_	
	1 1	Inspection	n Strin in	Tuhe	- 1	Cut Too Short	1	Misread	i		Power Loss/	Surge	- 1	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

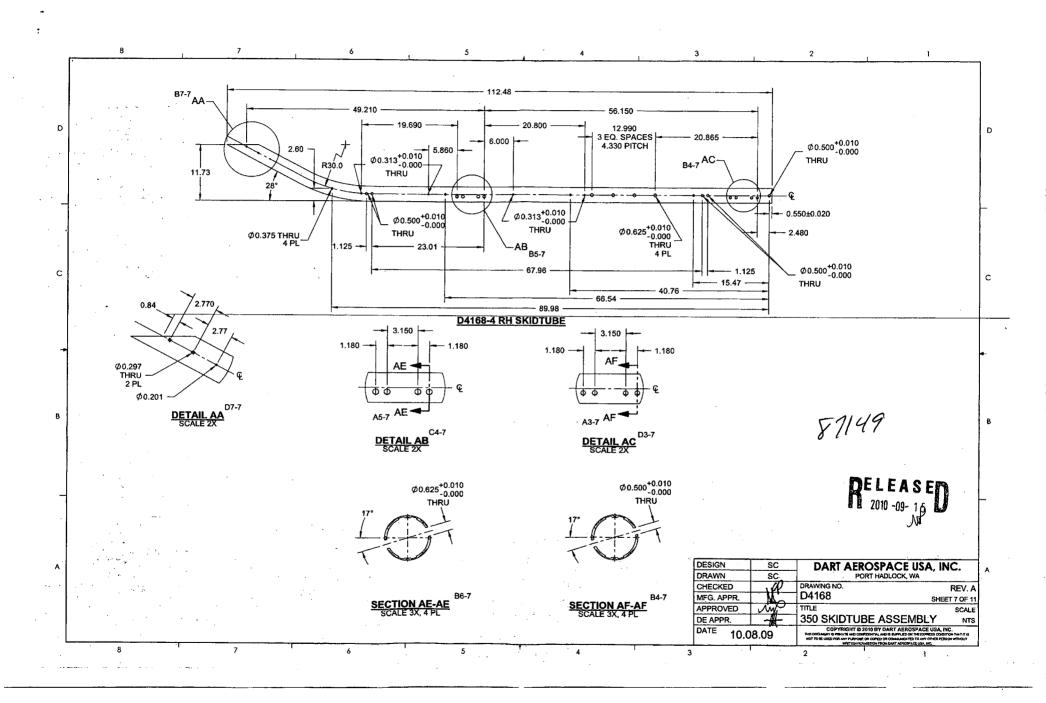
Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



												DQA:	Date	e:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE					7.
r		***										QA Closed:	Date	e:	
Work Ord	or.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Work Ord		· · · · · · · · · · · · · · · · · · ·				Rework	7		Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part (Nο					Scrap	1		Machining	Small Fab	\dashv	Pro	d. Eng. Coor.	\dashv	Quality
				···		Use-as-is	1		noforming	Finishing	\dashv		e/Packaging	ᅦ	Other
NCR	No.				·	Work Order Update			Large Fab	Composite	d		Supplier		
													<u></u>		
Root					Descri	ption of work order update		Initial	Ac	ction		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription	_	Date	Verification		QC Inspector
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Equip/Tooling	Ш														
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Landi						General	Γ	16		r	_	0	Г	\neg	Pressure/Forced
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		Centre No	t Concen	itric to t	^{J/\$} -	BOM/Route	<u> </u>	Hardwa		-			 -	4	Temperature/Cure Weld
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	ш	Heat Trea		- .		Countersink	\vdash	Mislabe		-		Positioned V	· -	 -	0.1
	1 I	Inspection	i Strin in	iube	1	Cut Too Short	1	lMisread		1		Power Loss/	Surge I	,	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

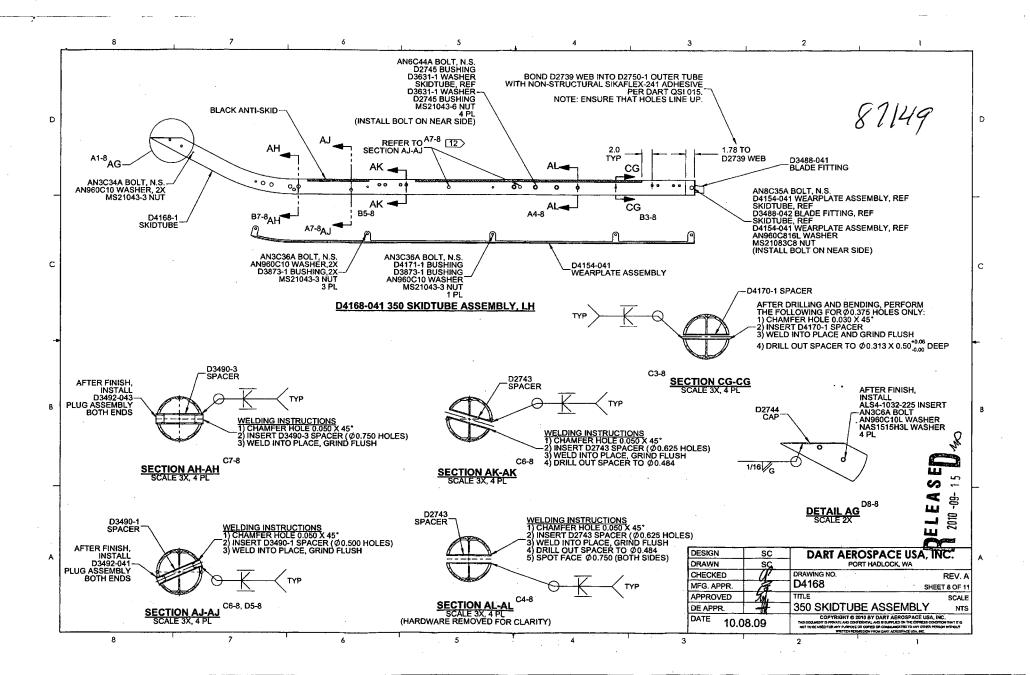
Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



NCR: Y	es / No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE	QA Closed:	Date:	``
Work Orde	or.				DISPOSITION				AGAINST DE	***	····	· · · · · · · · · · · · · · · · · · ·
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing				4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AUI	LT CATE	SORY				
Landin	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/I nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
[Torque W	aves in E	xtrusion	1	Drawing		Out of C	Calibration				

Out of Sequence

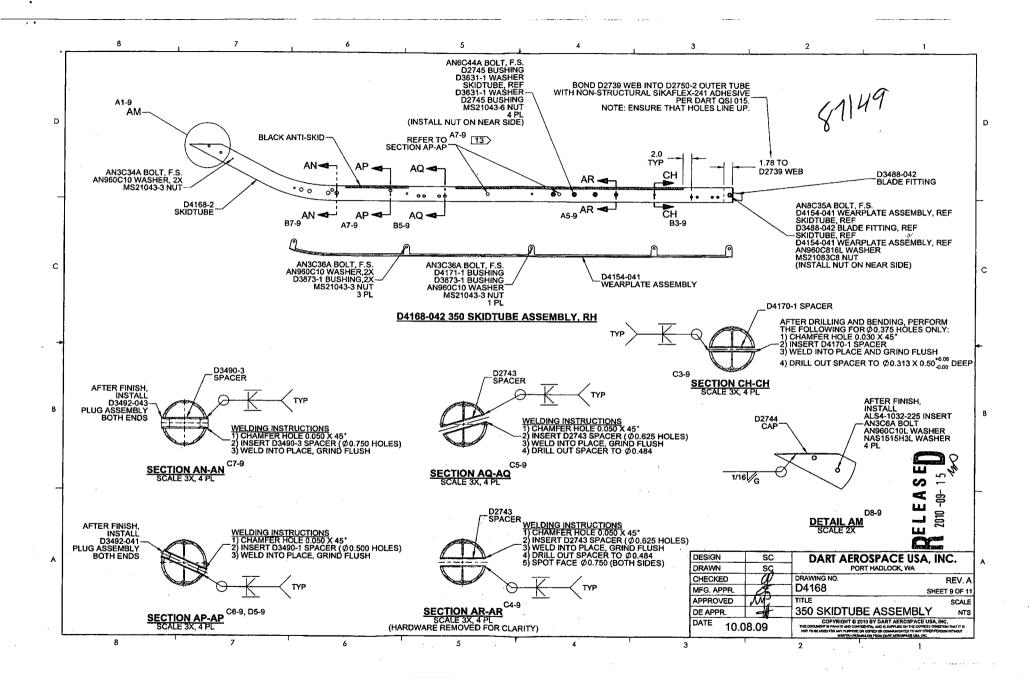
Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

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NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPI	DATE			
									,		QA Closed:	Date:	
Work Ord	ler: _					DISPOSITION		:		AGAINST DE	PARTMENT	PROCESS	,
Part No. NCR No.						Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
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Root Cause		Date	Step	Qty	l	ption of work order update or Non-conformance	1	Initial nief Eng		tion ription	Sign & Date	Verification	QC Inspector
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Out of Sequence

Outside Dimensions

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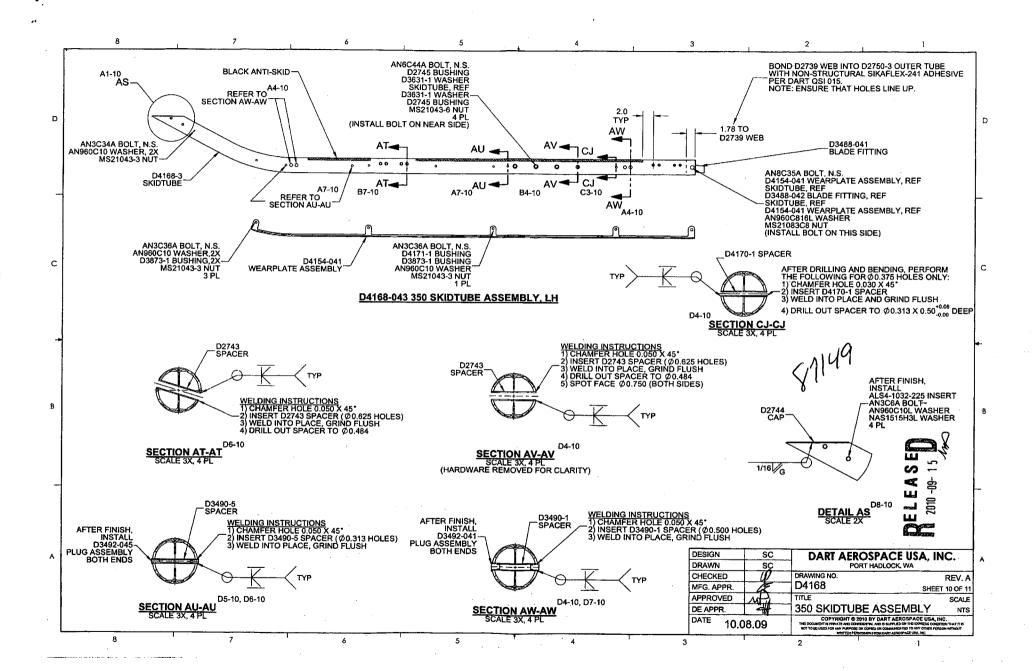
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Turning Sequence

Wave/Twist in Tube

Finish

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Work Ord	C1		·····	· · · · · · · · · · · · · · · · · · ·		Rework	7	1	Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1		noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR I	No				· · ·	Work Order Update]		Large Fab	Composite		Supplier	
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	R	Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

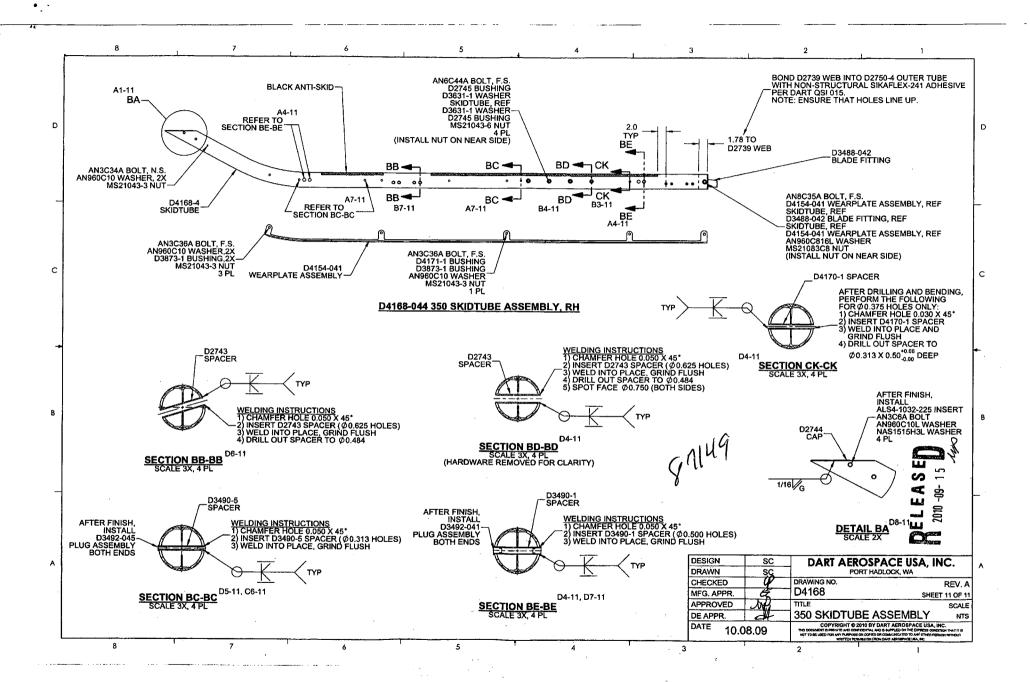
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



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										QA Closed:	Date:	
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NCR	No.					Work Order Updat	te		Large Fab Composite		Supplier	
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		Bending			[Bend		Grain		Ovalized		Pressure/Forced
•		Centre No	t Concer	ntric to (o/s	BOM/Route		Hardwa	re	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete	Part Incorred	ct	Weld
		Crushed/C	Crimped.			Burrs		Instructi	ions Incomplete/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	Part Moved		
		Heat Treat	t			Countersink		Mislabe	led	Positioned V	Vrong	_
		Inspection	Strip in	Tube		Cut Too Short		Misread		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset				
	Ш	Torque Wa	aves in E	xtrusior	ր [Drawing		Out of C	Calibration			
	-	Turning Se	•			Finish		Out of S	equence			
		Wave/Twi	st in Tub	e		Folio		Outside	Dimensions			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

NO. 300

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name:	Barday Elliott	
Job #:	87941	
Part #:	D350-636-011	
Description:	Seid	
Welding Pro	cess: Tig[/ Mig[]	
Base materie	l:	
Current: AC	CA DCI	

TEST REQUIREMENTS AND RESULTS

Visual:	pass[1]	fail[]
Incomplete Penetration:	pass[]	fail[]
Incomplete Fusion:	pass[]	fail[]
Cracks:	pass[/	fail[]
Overlap (cold lap)	pass[']	fail[]
Undercut:	pass[1]	fail[]
Pin holes:	pass[]	fail[]
Porosity (surface):	pass[/	fail[]
Coloration:	pass[]	fail[]
Burn through:	pass[]	fail[]
Overlap (cold lap) Undercut: Pin holes: Porosity (surface): Coloration:	pass[] pass[] pass[] pass[] pass[]	fail[fail[fail[fail[fail[

Qualifier Date of Test Coupon 12.07.26

Welder Box Oy Ellust Date of Test Coupon 12-07-26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

- 1- Pick D2600-3 Bent
- 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168
- 3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.
- 4- Locate DT off of blade fitting bolt holes and drill pilot holes for blade fitting
- 5- Drill fwd step holes using DT9616 detail . Ensure proper positioning.
- 6- Drill pilot holes using drill Jig DT8150 & DT8864A for first side only DT8864B for second side section BE-BE and BC-B€
- 7- Clecko DT8864B on second side of tube and drill pilot holes for section BE BE and BESSE ***SECOND SIDE***
- 8-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.
- 9-Open up holes of Detail a to 0.297" (total of 2 holes per side) +.201" holes Detail
- 10-Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

 A/R Aluminum Rod batch:

11-Grind welds flush as per Dwg D4168

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Second side

F (1500) 18:

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